

Work Order ID 93088***93088***

Page 1

November-14-12 9:51:29 AM

Item ID: D3272-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step

Start Date: 11/14/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/15/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

QC6- Inspect dimensions to drawing

0.00

110


QC

Memo

0.00

Quality Control

1  
12.11.14

① 12-11-14 
DAS
09
8-88

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Page 2

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Start Date: 11/14/12 Start Qty: 1.00 ***1***

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <i>WMA</i>	0.00							
120									
Packaging	Memo	0.00				<i>1</i>	<i>0</i>		<i>h</i>
Packaging									<i>12.11.14</i>
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							<i>12/11/15</i>
Quality Control									

W12.11.14

Picklist Print

November-14-12 9:51:28 AM

Page 1

Work Order ID: 93088

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 11/14/12

Required Date: 11/15/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	161.1300	1	1		12.11.14	

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	135.4	
81507	1.88	
83894	12.38	
88513	7.14	
89750	114	
WA013	9.36	
75781	2	
77612	7.36	



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

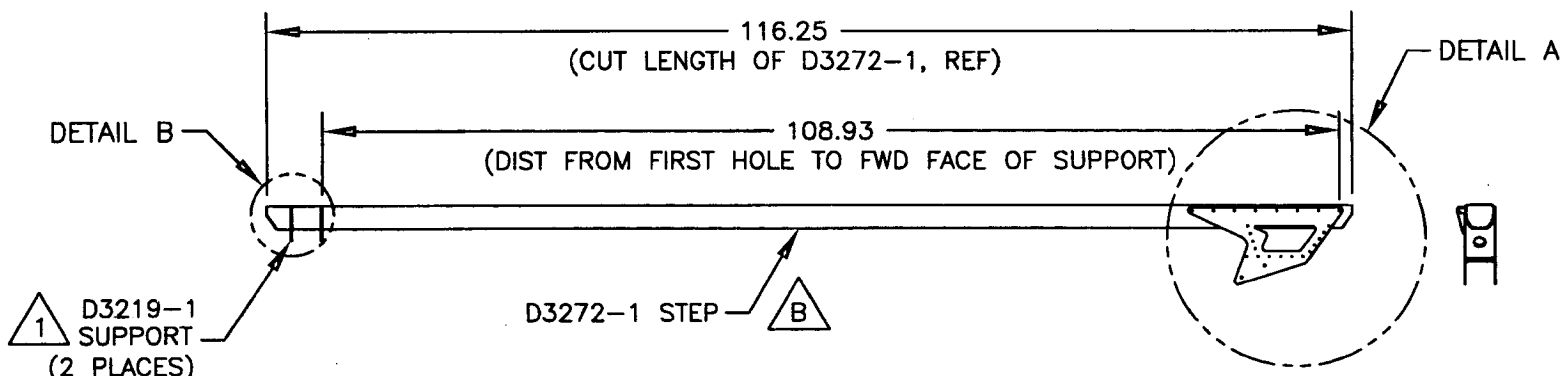
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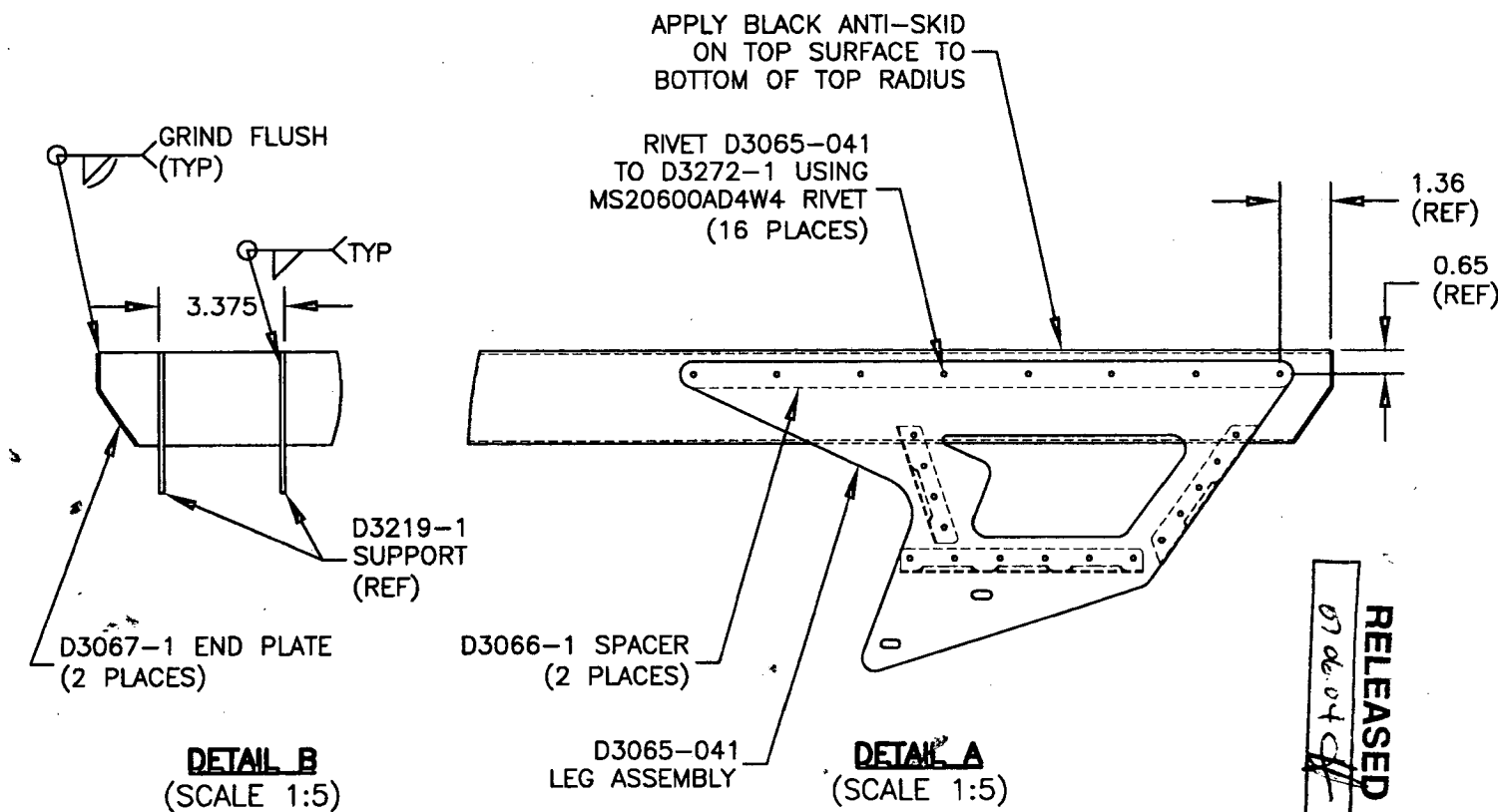
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DESIGN DQ	DRAWN BY J.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED C.E.	APPROVED J.B.	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	

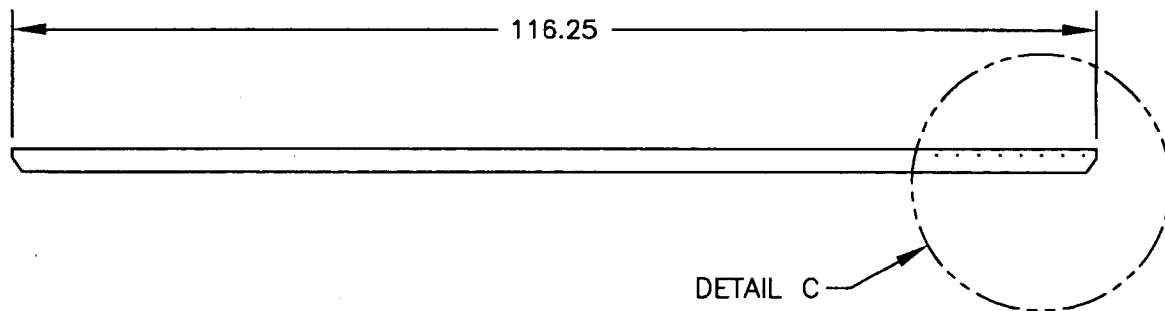


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

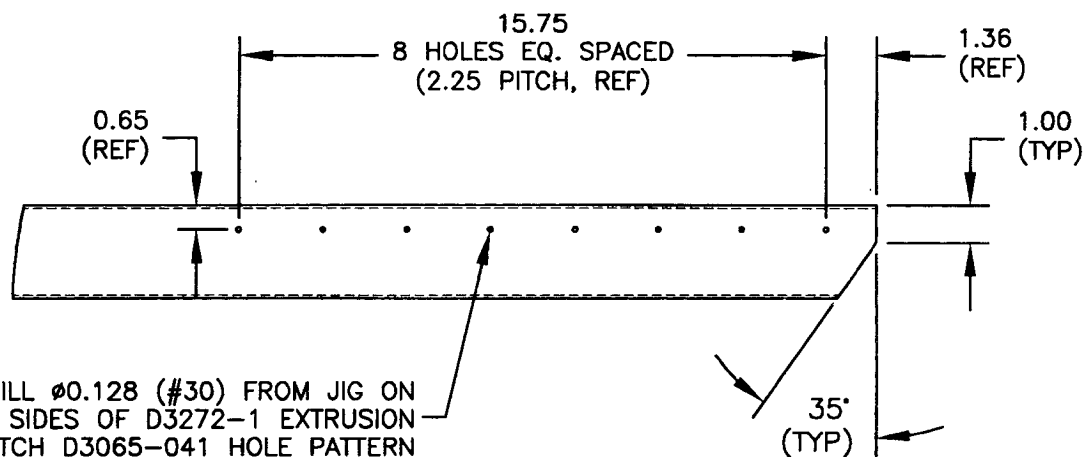




DESIGN	q	DRAWN BY	1	DART AEROSPACE LTD
CHECKED	CE	APPROVED	1	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
		SCALE	1:20	



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

